

Date: Wednesday, 1/11/2006 4:29:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)			
Job Number	: 25472						
Estimate Number	: 11001						
P.O. Number	: N/A			Part Number	: D26022		
This Issue	: 1/11/2006	S.O. No.	N/A	Drawing Number	: D2602 REV A1		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A		Type : MACHINED PARTS	Drawing Revision	: A1		
Previous Run	: 25141			Material	: N/A		
Written By	: SEE COMMENT BELOW			Due Date	: 1/30/2006		
Checked & Approved By	: SEE ABOVE DATE & USEC			Qty:	10		
Comment	: Est. E 04.02.25 Reformat KJ/RF			Um:	Each		
	Note: Issue with part number D2602-1						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M19059</u>	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut Blank per template DT8243	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA145 and Dwg D2602 Stack of 10 Identify as D2602-2	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

DL - 06/02/22 10

SB 06/02/24 10

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/02/26 10

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

use for 25446 w/o m/06/02/27 10

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/02/27

Job Completion



U 06.02.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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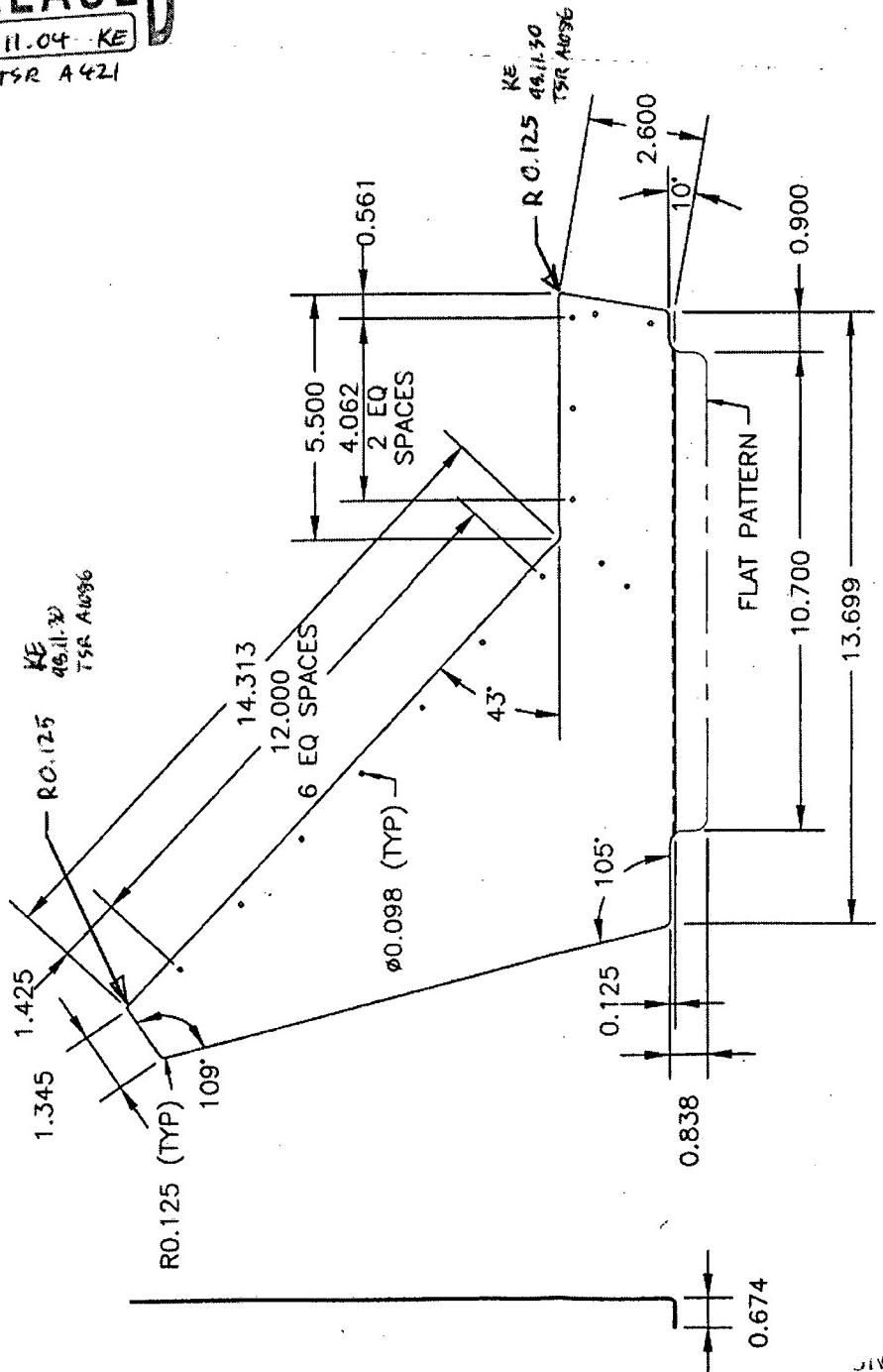
NOTE: Date & initial all entries



DESIGN <i>D</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SJ</i>	DRAWING NO. D2602	REV. A SHEET 1 OF 1
DATE 97.10.22		TITLE CONSOLE SIDE	SCALE 1:4
A	97.10.22	D2602 WAS D206-547-21/-22	
A1	<i>GP</i> 02.06.04	ADD FINISH	

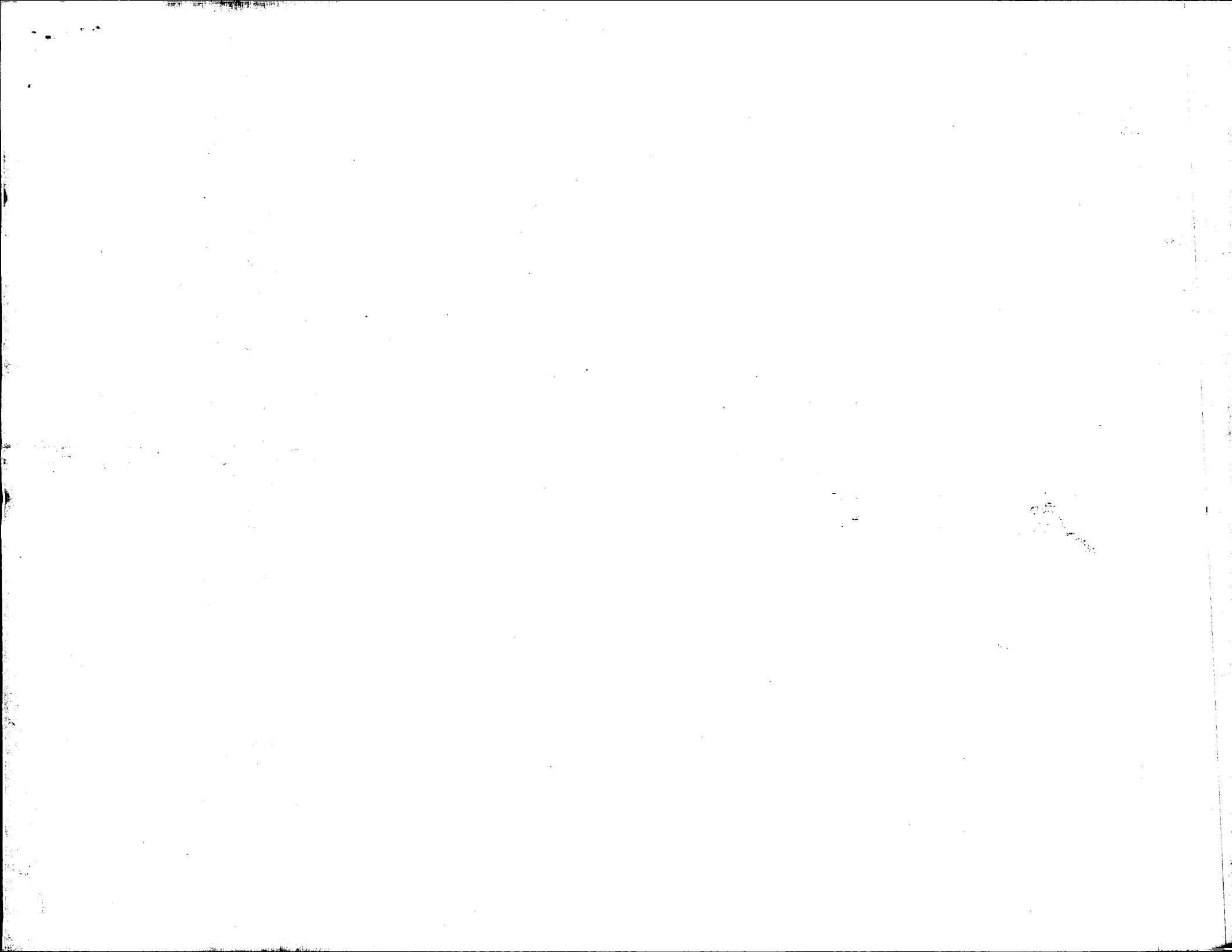
RELEASED
97.11.04 - KE
TSP A421

97.11.04 - KE
TSR A421



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2602
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER PART
D2602-1 SHOWN
D2602-2 OPPOSITE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



DART AEROSPACE LTD	Work Order:	25472
Description: CONSOLE SIDE LH	Part Number:	D2602-2
Inspection Dwg: D2602 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<i>Mf</i>	Audited by:	<i>Er</i>	Prototype Approval:	
Date:	06/02/26	Date:	06/02/26	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

